

Work Order ID 56874

Thursday, March 11, 2010 2:20:19 PM



ASAP

Page 1

Item ID: D3290-041

Revision ID:

Accept



Setup Start



Item Name: Replacement Window Assembly

Stop



Start Date: 3/11/2010 Start Qty: 6.00

Required Date: 3/16/2010 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: ME

Date: 10-3-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3290

DEO Rev C1

100



Waterjet

FLOW WATER JET

0.00

FLOW CNC Waterjet

6061. 063

Memo

0.00

1-Cut as per Dwg D3290 (use prog. for D3290-1)

Dwg Rev: C1

Prog Rev: C1

2-Deburr if necessary

B 10-3-15

8

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B 10-3-15

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

8.06/16

XS

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
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Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

10/03/14

15 0

140



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

START TIME: 3:20pm
OVEN TEMPERATURE: 320°
FINISH TIME: 2:50pm

0.00

0.00

10/03/16

25 0

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

10-3-17

8 9

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Cust Item ID:

Customer:

Reference:



Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Small Fab

Small Fab

Small Fab

Memo

Assemble as per Dwg D3290

Clean D3290-041 and place in plastic wrap

0.00

0.00

SAN

10-03-17



170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

5/10/17



180



Packaging

Packaging

Identify as per dwg & Stock Location 219

Memo

0.00

0.00

10-3-17 SLP

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Accept



Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/17
mf
10-3-17

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Picklist Print

Thursday, March 11, 2010 2:20:18 PM

Page 1

Work Order ID: 56874

Parent Item: D3290-041

Parent Item Name: Replacement Window Assembly

Comments: IPP B 05.05.25 Added Step 11 KJ/JLM
IPP C 06.05.09 Ecn 798 EC
IPP Rev: D Now on Waterjet 06-06-16 JLM
IPP rev E rev C dwg 07.09.28 EC verified by: DD

Start Date: 3/11/2010

Required Date: 3/16/2010

Start Qty: 6.00

Required Qty: 6.00

M6061T6S.063

Purchased

No

100

sf

286.3841

23.6842



6061-T6 .063 Sheet

32.0

B 10-3-15

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

286.3841211

110551

18.1841211

113608

268.2

Manufactured

No

160

f

145.9302

39.0000

113608

+B = 52

SAD 10-3-17

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

145.9302

48285

145.9302

✓ 52.000

(D2126-0780) cut qty (1) at 78.00" as per dwg
per kit

D3290-3

Manufactured

No

160

Each

9.0000

6.0000



Window

SAD 10-03-17

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST221

9

55046

9

✓ 8

Dart Aerospace Ltd

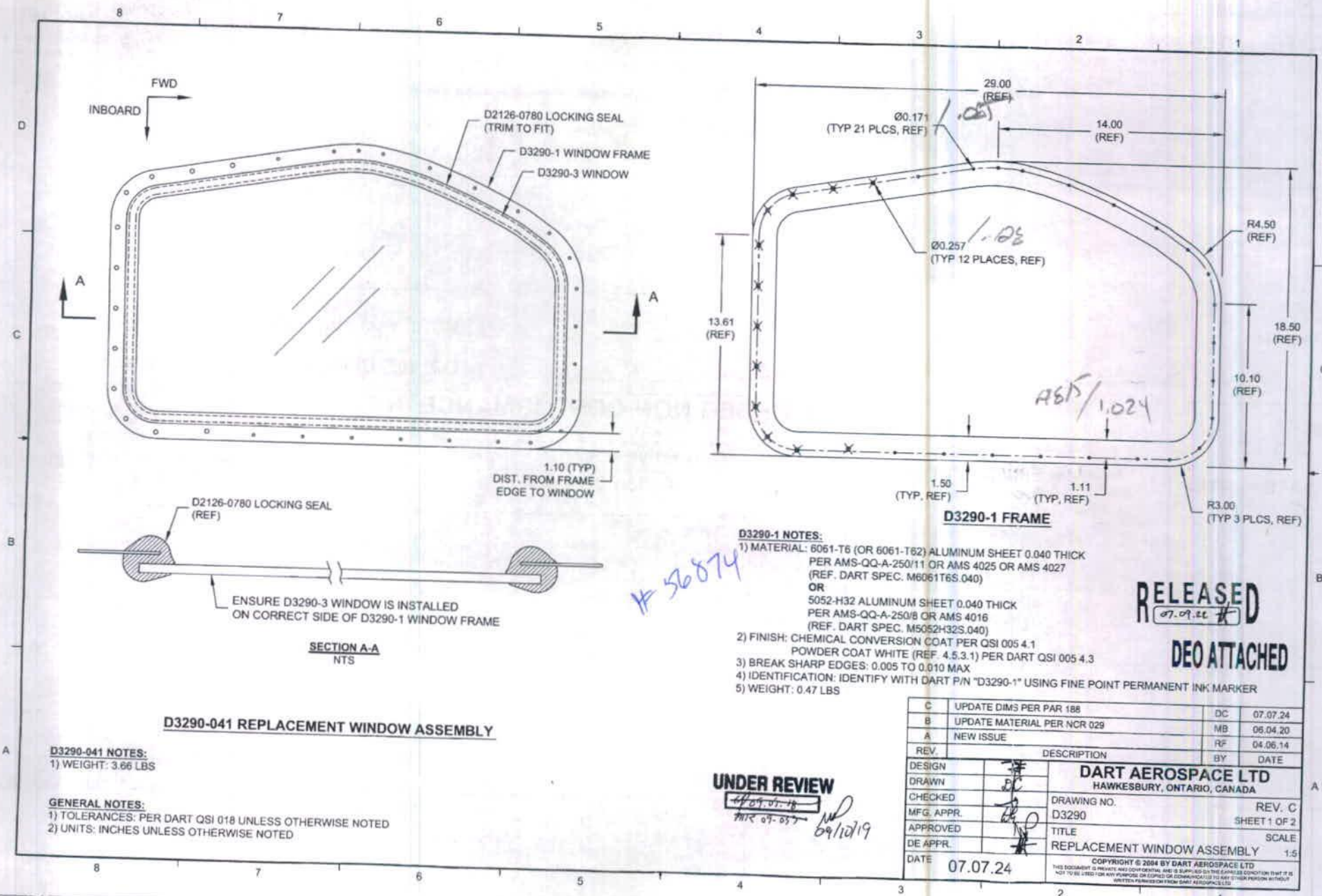
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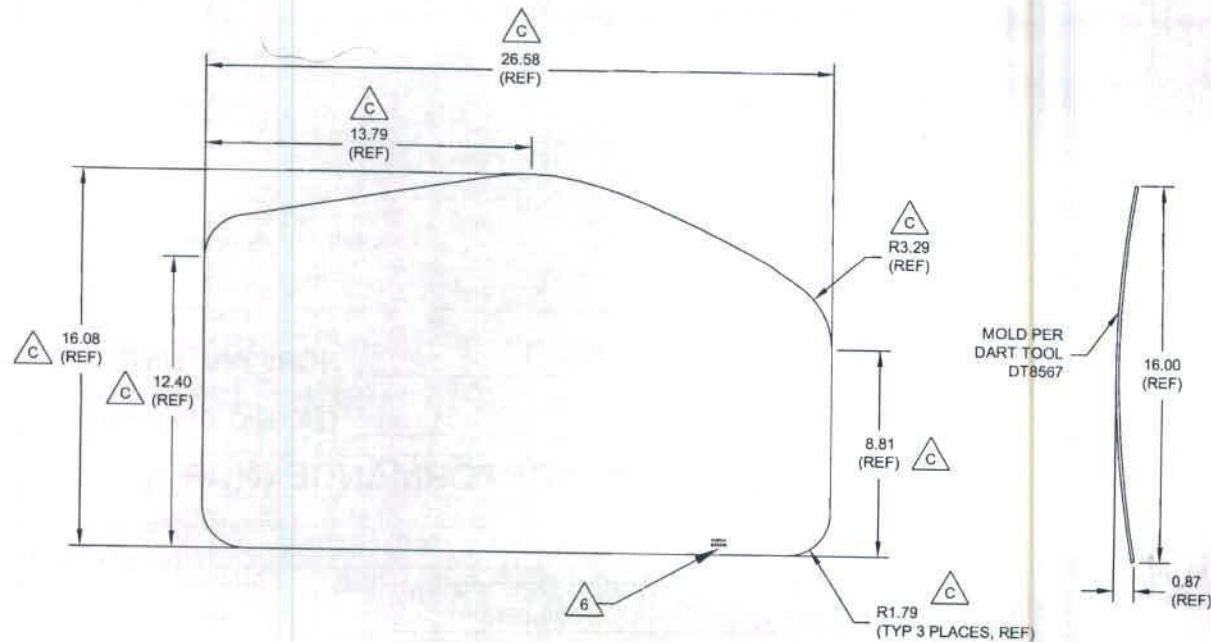
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D3290-3 WINDOW

- D3290-3 NOTES:**
- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) REMOVE SHARP EDGES
 - 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
 - 7) WEIGHT: 1.87 +/- 0.42 LBS
 - 8) MOLD PER DART TOOL DT8567

#56874

UNDER REVIEW
DEO ATTACHED
RELEASED
07.07.24

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3290	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY 1:1	
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMERCE OR COMMUNICATIONS TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>qp</i>	CHECKED <i>ib</i>	MFG. APPR. <i>FE</i>	APPROVED <i>MD</i>		DE APPR. <i>#</i>		
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21		DATE 09/09/21		

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

#56874

RELEASED
 2009-10-09
WTF

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